

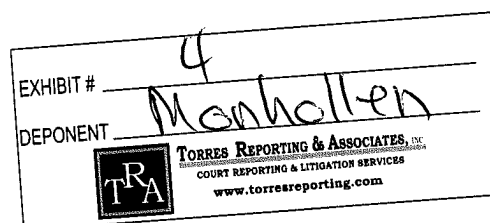
From: T Gene Clemons
Sent: Wednesday, April 18, 2012 7:52 PM
To: Daniel Monhollen; Daniel P Boudreaux; Elizabeth M Cromwell; Gary O1 Simpson; Glen E Powell; Ivy Alberes; Percy L Bell; Scot W Miller; Thomas Miller; Vandell R Sturgeon; Wade S Miller; Jay S Schickling; Scott J Whitlow; Kent M Templet
Cc: John P Gay; Frank S Stidham
Subject: Mini- shutdown V/A charter
Attach: 4.6.12 meeting minutes.doc; Action items 4.18.12.xls

Attached are the meeting minutes from 4/6 as well as an action item list from todays meeting.

Our next meeting is on 5/2. Please come prepared to update the team on your items.

Thanks,
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Program Name: S/D Insp vs Mini S/D
Attendees: Gene, Daniel, Dan, Gary, Wade, Scott

Goal: Prevent Unplanned S/D's, Reduce Frequency and Duration of Major Shutdowns

Scope: Schedule "mini" Shutdowns to facilitate Goals mentioned above. Items to evaluate:

- **Relief Valves**
 - RV's are normally shopped during major s/d's
 - Need list of all RV's see: \\Burs1\shared\common\Tracking Sheets
 - Boiler RV's – Sulfur Boiler RV's cannot be changed out without going cold. Would have to drain the boilers.
 - Check PSM manual to see if it sets frequency. (Gary)
 - Need to analyze data from Groquip inspections to see if frequency can be extended. (Gary)
 - Spent side could be done during a spent outage.
 - Evaluate number of spares we need to buy. (Vandy)
- **Equipment Inspection**
 - Coolers, in line tanks, anodic protection, economizers, etc
 - Cold side of SPENT BOILER tube replacement. Can we make it until Fall '13? (Gary)
 - 98 and 99 plate and frame coolers – Were reworked in 2011.
 - FAT cooler was not pulled and reworked in 2011.
 - Dyna wave – need to discuss with Terry Cowley (Gene)
 - Need to pull inspection data from 2011 s/d and evaluate. (Gary)
 - Dry tower – monitor with stick tests. Condition of distributor system is poor. NEED TO ALLOCATE MONEY TO PURCHASE. (Glen)
 - Stripper Tower – should be ok
 - Blower – ok
 - Sulfur Furnace – Refractory in poor condition? Shell repair done April 11.
 - Sulfur Boiler – Experienced tube leak in '11. Duet recommends replacement in '13. Need to discuss with Scott. (Gene)
 - Converter boiler – Should be good.
 - Converter – catalyst life?? (Dan)
 - IPAT – needs inspection to determine what's causing the pluggage in the analyzers. Might could deinventory and open up for inspection in a 1 day outage. Would have to be very well

planned. Candles may be damaged as a result of the sulfur boiler leak.

- **Interlock Checks**
 - Since PTR done in 2011, the number of required safety interlock checks have been minimized. All can be done in one day outages.
- **Catalyst life**
 - Dependent upon number of boiler leaks or process upsets.
 - Should be able to extend 6 months.
 - Monitor pressure drop monthly.
 - Performed a PEGASYS in Dec 2011. Could run another as needed since we now have a baseline.
 - Catalyst must be reserved a year in advance. Talk with Kirk about reserving in case we need to do a hot screen in the Spring. (Gene)
 - Hot screen would require a 6 to 7 day outage.
- **Control Valves**
 - Need to get list. (Bo)
 - May need to purchase some of the larger valves to assure the work could be done during a 1 day outage.
 - Need to evaluate data from the valve shops to determine which valves could be extended. Bo has the data. (Gene)
- **Refractory Life**
 - Need to talk with Jay Schickling. (Gene)
 - Need to discuss the new design for the RJS transition piece. (Gene)

EXPECTATIONS FOR SUCCESS (Milestones)

1 Month: Evaluate items mentioned above to determine practicality of inclusion in mini shutdowns.

3 Month: Comprehensive list of work that can be accomplished during mini-shutdowns.

6 Month: Detailed plan / schedule that includes required spare parts purchases, frequency at which each item must be done to meet PSM requirements and resource requirements.

METRICS (KEY PERFORMANCE INDICATORS)

1 Increase time between major shutdowns from 2 years to 2.5 years.

2 Reduce RM workload during major shutdowns.

	A	B	C	D
1	Item Description	Responsibility	Timing	Status
2	Need list of RV's	Gene	18-Apr	List is on shared drive at: \\Burs1\shared\common\Tracking Sheets
3	Check PSM requirements on frequency of RV inspections	Gary	18-Apr	4/18 PSM manual says to check every major s/d on a 2 to 2.5 years, but not to exceed 5 years.
4	Analyze data from Groquip to identify failure modes. This will help determine whether frequencies can be extended	Gary	16-May	4/18 Awaiting call back from Groquip. Plan is to get Steve from Groquip to come in and train us on use of their database.
5	Evaluate and make recommendation on number of spares we will need to purchase	Vandy	16-May	4/18 - Charter identified in VA to review and upgrade critical spares list. This item will be incorporated in that charter.
6	Do new or rebuilt valves have a "shelf life"	Gary	29-May	This is just for understanding...not a barrier.
7	Can we make run till Oct 2013 with current spent boiler tubes?	Gary	30-May	Consider purchasing spare tubes in case we need them.
8	Discuss dynawave system with Terry Cowley to identify any barriers to extending inspection frequency.	Gene	16-May	
9	Evaluate all equipment inspection data from 2011 s/d	Gary	30-May	4/18 - Evaluation has begun
10	Put dry tower internals on capital forecast	Glen	16-May	4/18: need to go through the cost/cap decision tree. Need estimate on replacement.
11	Discuss sulfur boiler with Scott Whitlow	Gene	30-May	Capital forecast 2015. Should we do anything to prepare for an unscheduled s/d?
12	Can we predict converter catalyst life?	Dan	30-May	Can predict under normal operating conditions.
13	Talk with Kirk to see if we need to reserve catalyst in case of a hot screening in Spring 2013	Dan	16-May	
14	Evaluate data from Control Valve inspection to determine if they can be extended	Gary	30-May	4/18: need to discuss with John H Carter and DMC.
15	Get Jay's thoughts on refractory life	Gene	16-May	
16	Talk with Jay about new design for RJS transition piece	Gene	30-May	

	A	B	C	D
	Life of tower pumps? Availability			
17	of parts?	Vandy	30-May	